

Date: Friday, 25/07/2008 4:20:49 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 40761		
Estimate Number	: 13507		
P.O. Number	:	Part Number	: D21952
This Issue	: 25/07/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2195 REV C
First Issue	: / /	Project Number	: N/A
Previous Run	:	Drawing Revision	: C
	Type : SMALL /MED FAB	Material	:
Written By	:	Due Date	: 20/08/2008
Checked & Approved By	: <u>JP 08.7.25</u>	Qty:	2 Um: Each
Comment	: Est Rev:A 08-07-24 new issue ec verified by:dd		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 Sheet .063
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Comment: Qty.: 0.2216 sf(s)/Unit Total : 0.4431 sf(s)
 304 SS Sheet 0.063" thick
 batch: 108 724 HB 8-8-21

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2195
 Dwg Rev: C
 Prog Rev: C

HB 8-8-21

③

2-Deburr if necessary HB 8-8-21

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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HB 8-8-21

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

S 08/08/01 (x8)

5.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE

Bend as per dwg D2195

S03 08/08/25

③

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 25/07/2008 4:20:49 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 40761

Part Number: D21952

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/08/25 (x3)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock
Location: 18

8/8/25

510 (3x)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/26

Job Completion



08-08-26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

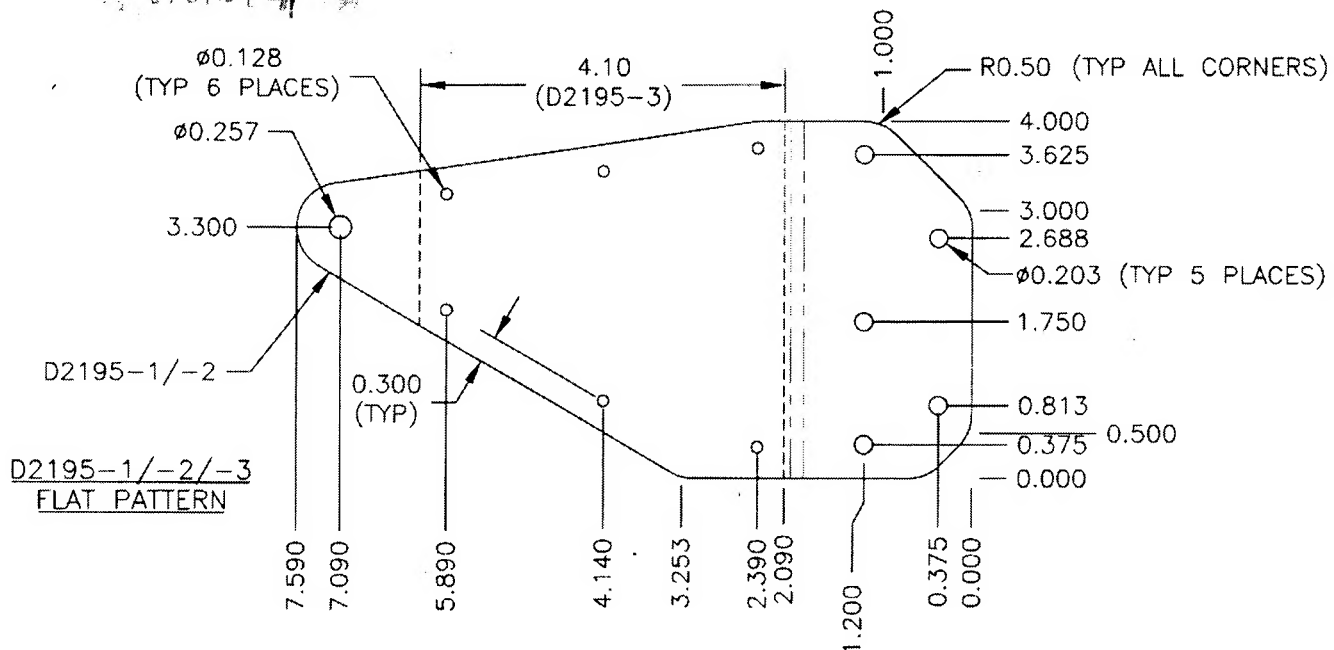
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2195	REV. C SHEET 1 OF 1
DATE 03.05.28	TITLE BRACKET		SCALE 1:2
B	93.09.23	RE-DESIGN	
C	03.05.28	REDRAW; D2195-3 NOW 0.5" THICK	



D2195-1/-2

- 1) MATERIAL: AISI 304/316 S.S.
0.064" THICK (M304S16GA)

D2195-3

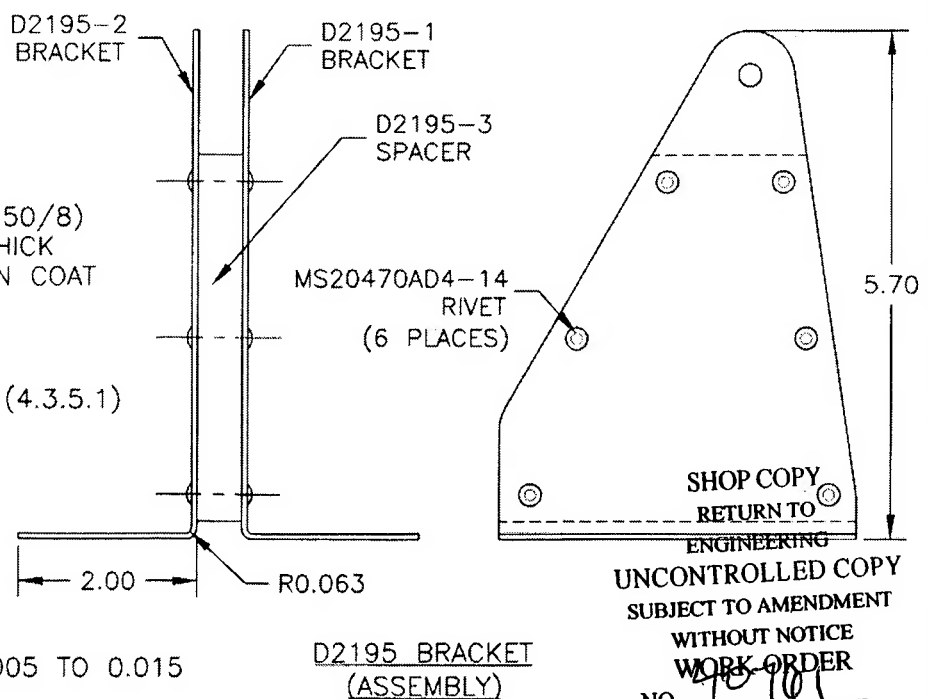
- 2) MATERIAL: 5052H32 (QQ-A-250/8)
0.500" THICK OR 4x0.125 THICK
- 3) FINISH: CHEMICAL CONVERSION COAT
PER DART QSI 005 4.1

D2195 BRACKET (ASSEMBLY):

- 4) FINISH: POWDER COAT WHITE (4.3.5.1)
PER DART QSI 005 4.3

GENERAL NOTES:

- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.015



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